

Date: Thursday, 12/20/2007 12:14:37 PM
 User: Dominique Dube

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : PB67-43001-85
Job Number : 36351	
Estimate Number : 10804	
P.O. Number :	Part Number : PB674300185
This Issue : 12/20/2007 S.O. No. :	Drawing Number :
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 00015	Material :
Written By : <u>W</u>	Due Date : 1/5/2008 Qty: 4 Um: Each
Checked & Approved By : <u>W</u>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

ISSUE TRAVELER

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

CUT AS PER DWG B67-43001-191

3.25" X 4.25" 0.063" THK 6061T6 B 105225

B 07-12-21

CUT & DRILL HOLES AS PER DWG B67-43001-193

1.00" X 1.50" 0.125" THK 6061T6 B 105646

B 07-12-21 (4) of EACH

CUT AS PER DWG B67-43001-339

1.688" X 3.12" 0.063" THK 6061T6 B 105225

B 07-12-21

DE-BURR

10061/04 (4)

3.0

M6061T6S063



Comment: Qty.: 0.10000 sf(s)/Unit Total : 0.40000 sf(s)
 6061-T6 .063 Sheet

See step #2.0

4.0

M6061T6S125



Comment: Qty.: 0.01090 sf(s)/Unit Total : 0.04360 sf(s)
 6061-T6 .125 Sheet

See step #2.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PB67-43001-85

Job Number: 36351

Part Number: PB674300185

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M6061T6S063



Comment: Qty.: 0.03840 sf(s)/Unit Total: 0.15360 sf(s)
6061-T6 .063 Sheet

See stg 2.04

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-12-21

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

02/12/24 x 4 of each.

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Debur first

CUT IN HALF AS PER DWG B67-43001-195

4.25" LONG D2914-142

B 11306

DE-BURR

08-01-04 4

9.0

D2914142



Comment: Qty.: 1.00000 Each(s)/Unit Total: ~~1~~ 00000 Each(s) *min 2000 like*
3" Outer Tube LAMA

08-01-04 4

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-07 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

WELD AS PER DWG B67-43001-85

08-01-07 4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-01-08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PB67-43001-85

Job Number: 36351

Part Number: PB674300185

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 0806168

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

CHEMICAL CONVERSION COAT AS PER QSI005 4.1 (ALODINE)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

POWDER COAT GREEN SANDTEX AS PER QSI005 4.3 (4.35.8)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

PICK MS21075L3 NUT PLATE QTY 4 B m106576

PICK CCR264SS3-4 BLIND RIVET QTY 8 B

INSTALL NUT PLATE WITH RIVETS AS PER DWG B67-43001-85

19.0

MS21075L3



Comment: Qty.: 4.00000 Each(s)/Unit Total : 16.00000 Each(s)
Nutplate

MF 08-01-07 4

PTD

08-01-07 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-01-07	18	Use ms 20426 AD 3-4 # m102404 x (16) instead of CCR264SS3-4. + Use ms 20426 AD 3-3 # m19099 x (16)	mr	08-01-07		08.01.07	08/01/08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: PB67-43001-85

Job Number: 36351

Part Number: PB674300185

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

CCR264SS304



Comment: Qty.: 8.00000 Each(s)/Unit Total: 32.00000 Each(s)

RIVET

2008.01.08 4

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

SEND TO TULMAR FOR FOAM & FABRIC COVERING

PO

See 210: 36981 P/O: 5440 c2

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE & INSPECT FOR TRANSIT DAMAGE

23.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

IDENTIFY & PLACE IN STOCK

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



20.1 de 25 inspect to correct step

2008/1/08 (4)

min 2008/1/28 (4) W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

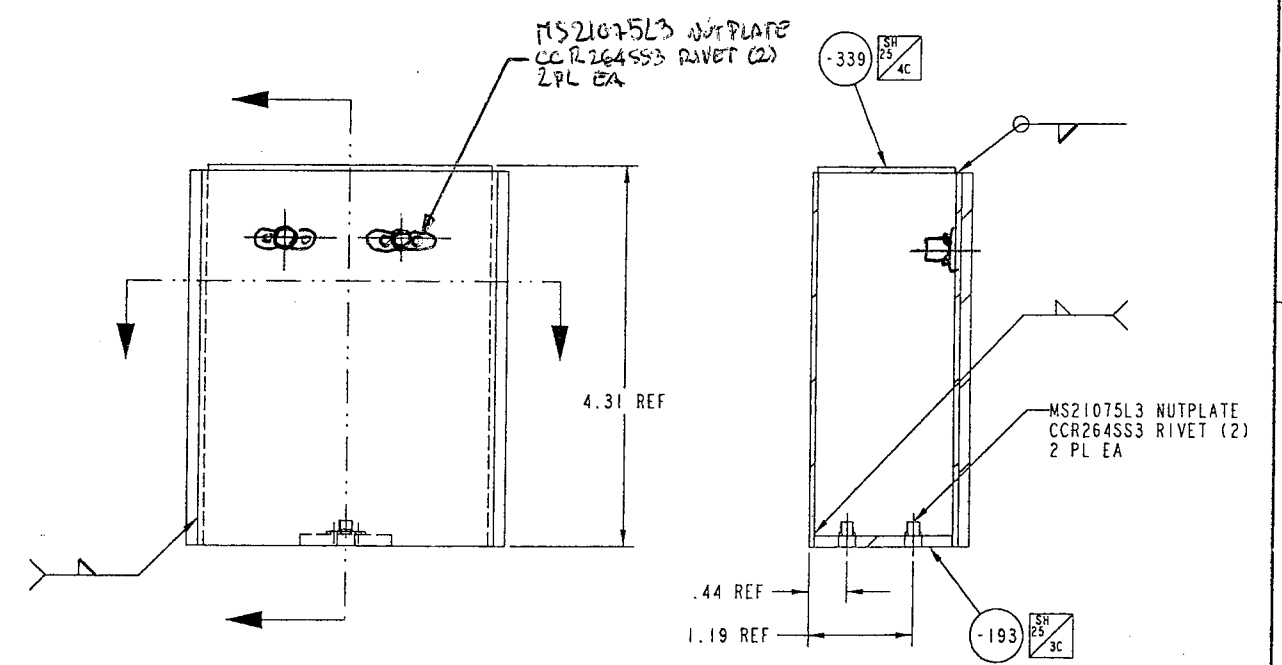
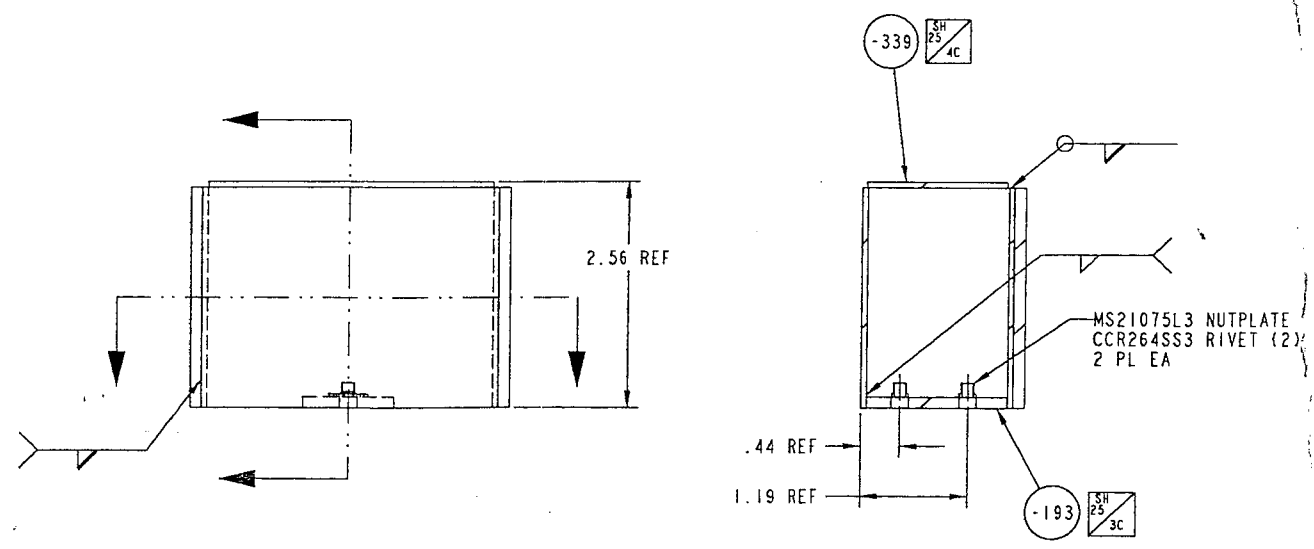
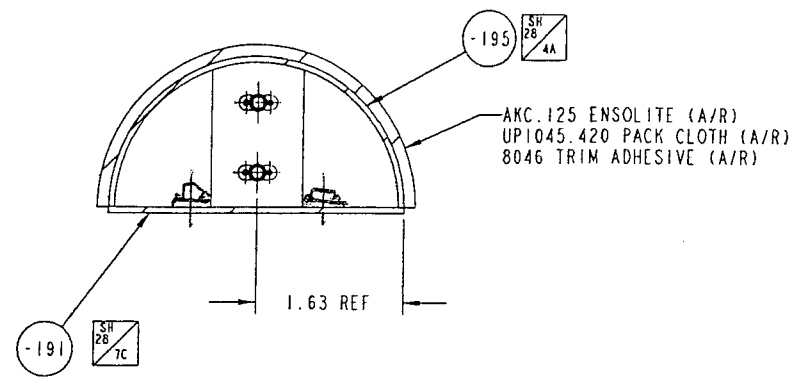
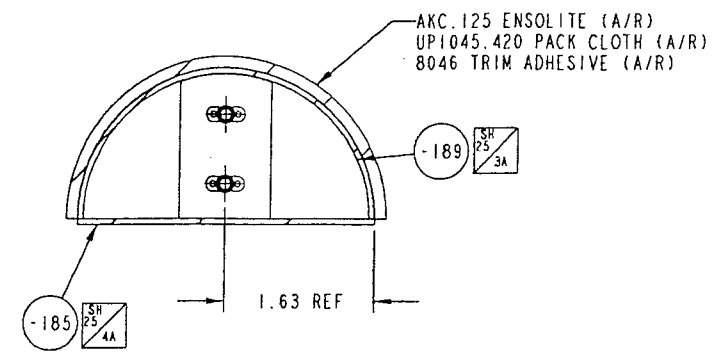
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
11-01-20



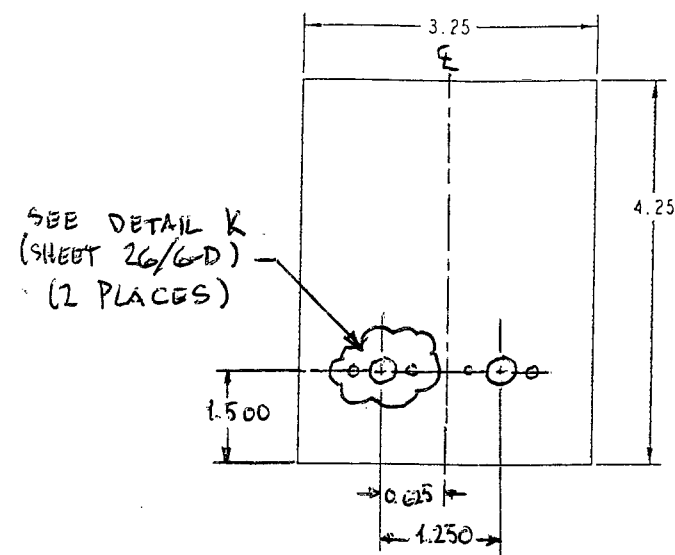
⑥ -83 SHORT D-PAD ASSEMBLY
SCALE 1.000

② -85 LONG D-PAD ASSEMBLY
SCALE 1.000

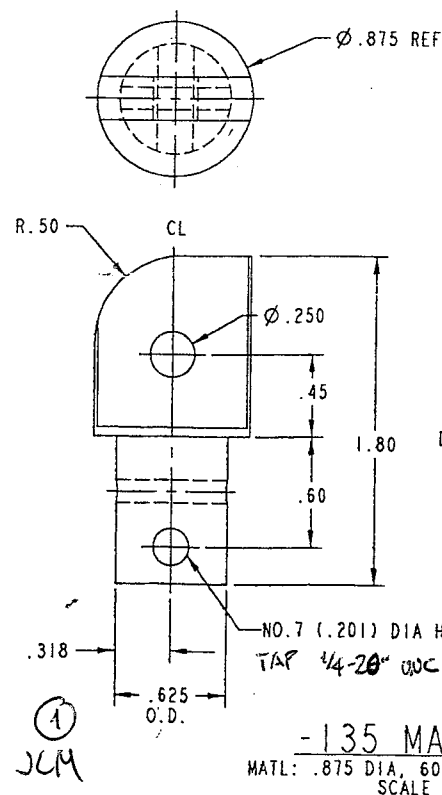
REFERENCE ONLY

ORIGINAL

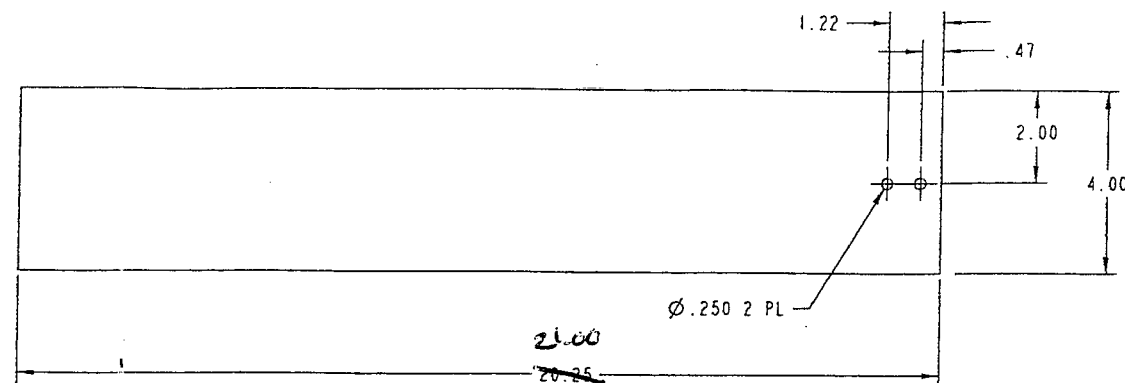
RELEASED
#06.01.70



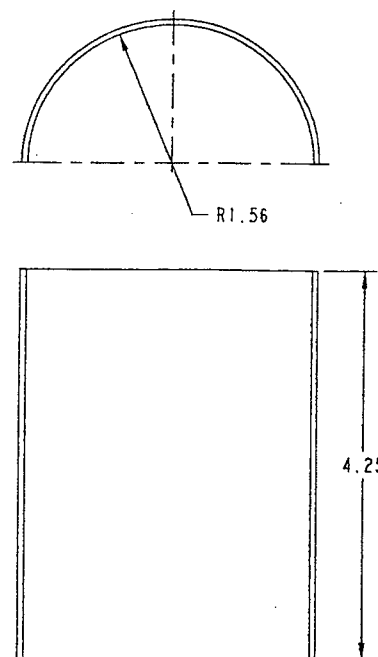
② -191 D-PAD BACK PLATE
MATL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000



① -135 MALE EYE
MATL: .875 DIA, 6061-T6, QQ-A-200/8
SCALE 2.000

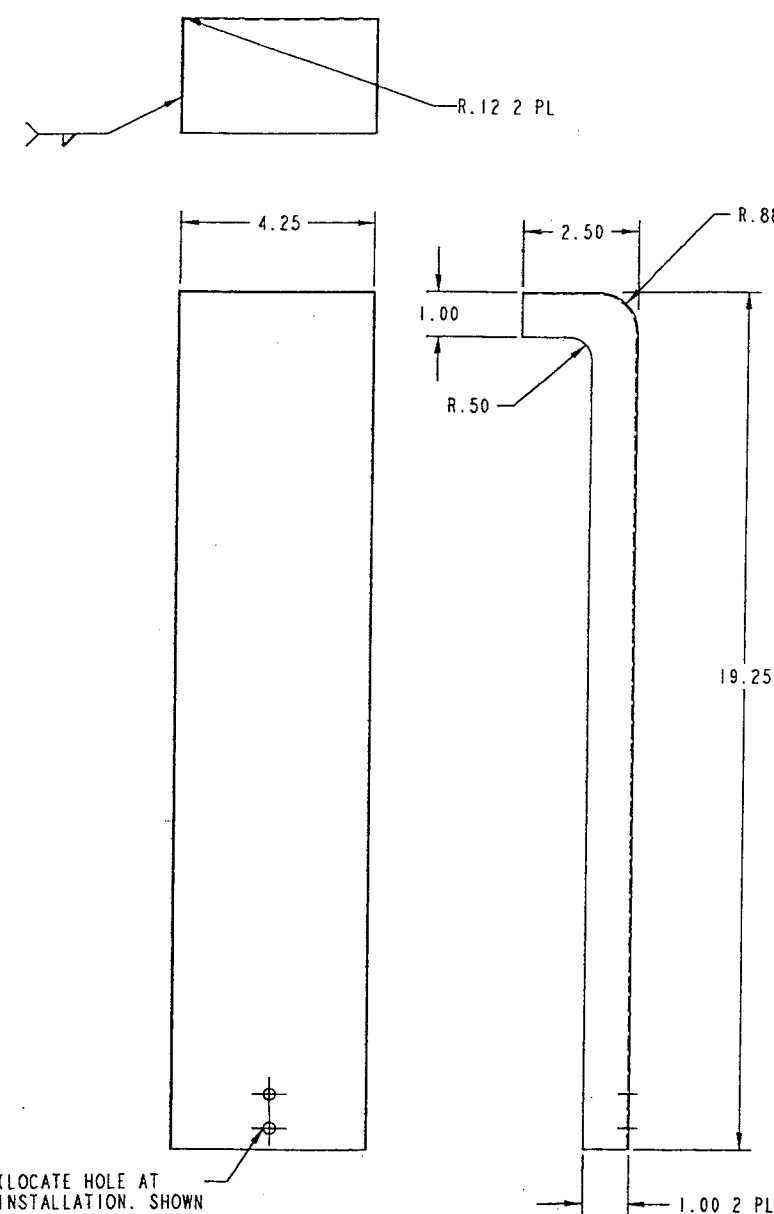


② -177 SHORT SUPPORT PLATE
MATL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500

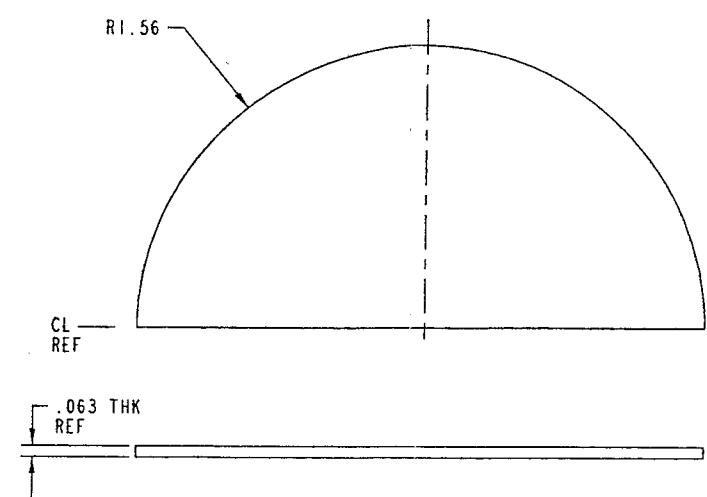


② -195 D-PAD FACE PLATE
MATL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000

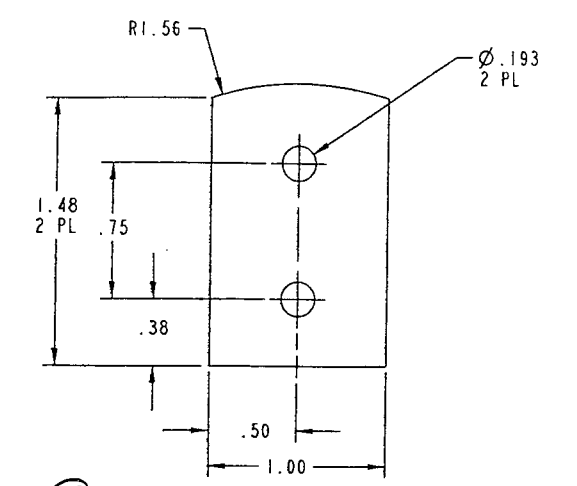
RELEASED
06-01-20



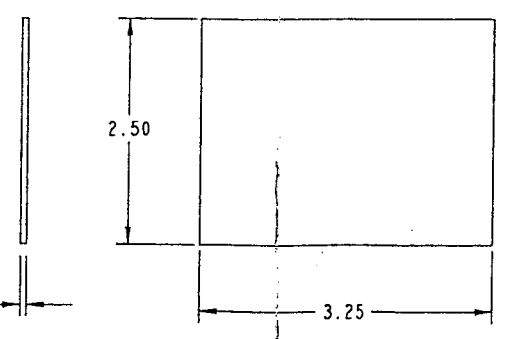
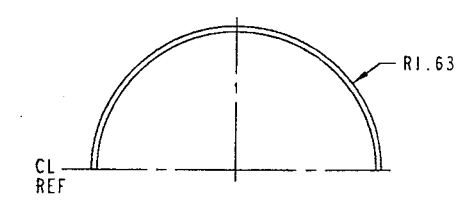
② -69 90 DEGREE COVER PLATE
MATL: .032 THK, 6061-T6, QQ-A-250/11
SCALE 0.500



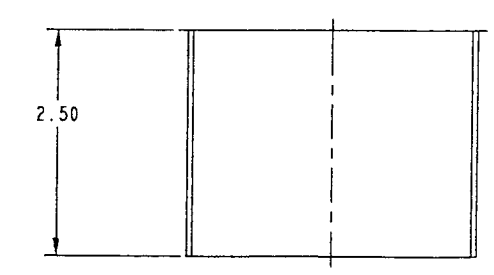
⑧ -339 D-PAD TOP
MATL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



⑧ -193 D-PAD BASE
MATL: .125 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



⑥ -185 D-PAD BACK PLATE
MATL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000



⑥ -189 D-PAD FACE
MATL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000

ORIGINAL

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	B.	Audited by:		Prototype Approval:	
Date:	07-12-21	Date:	7/12/24	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

